

Date: Thursday, 27/11/2008 2:16:51 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 BEARPAW INSTALLATION KIT (48")
 Job Number : 43822
 Estimate Number : 12283
 P.O. Number :
 This Issue : 27/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 41855
 Written By : 208.11.27
 Checked & Approved By :
 Comment : Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC
 Est Rev:G 06-08-28 As per Rev E JLM
 Est Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC
 Est Rev:I 08-10-01 New Manufacturing Method JLM Verified By:EC

Part Number : D205564011
 Drawing Number : D2521
 Project Number : N/A
 Drawing Revision : J
 Material :
 Due Date : 04/12/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



for JLD 08/12/03



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

Scalab

2.0 MFG ENGINEERING MFG ENGINEERING



Comment: MFG ENGINEERING
 Program Batch Number

208.11.28

3.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 8.4000 sf(s)/Unit Total: 16.8000 sf(s)
 blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: 109186 18 8-12-2

(4)

4.0 WATER JET FLOW WATER JET



18 8-12-3



Comment: FLOW WATER JET
 Cut Blank as per D2521 blank file

5.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 (2) Bearpaws Make (1) kit

N.A 09/01/14

Date: Thursday, 27/11/2008 2:16:51 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 43822

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

H.A 09/01/14

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/01/14

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/01/16 (4)

8.0

D2182B

Rubber Cushion



Comment: Qty.: 3.7000 f(s)/Unit Total : 7.4000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion *42737*

Lu

9.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block *342099*

Lu

10.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer *342908*

Lu

11.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp *40902*

Lu 9/01/21 (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

*Job Number: 43822

Part Number: D205564011

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 D3544041 Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

CLAMP

Batch: 41905

13.0 AN413A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M109285

14.0 AN415A Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN4-15A

Bolt

M109148

15.0 AN960JD416 Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416

Washer

M109242

16.0 MS21042L4 Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

Batch: M109282

17.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Rev C 9/1/21

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 43822

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/26 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-01-22

DART AEROSPACE LTD		Work Order: 43822
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.260	✓			
B	0.90	0.96	0.925	✓			
C	0.27	0.330	0.310	✓			
D	0.470	0.530	0.505	✓			
E	21.740	21.760	21.750	✓			
F	0.72	0.780	0.752	✓			
G	0.35	0.410	0.379	✓			
H	11.490	11.570	11.500	✓			
I	3.41	3.47	3.44	✓			
J	11.790	11.810	11.800	✓			
K	9.47	9.53	9.495	✓			
L	7.190	7.210	7.200	✓			
M	6.910	6.970	6.94	✓			
N	44.47	44.530	44.500	✓			
O	6.590	6.650	6.620	✓			
P	0.940	0.980	0.955	✓			
Q	18.97	19.03	19.000	✓			
R	0.350	0.410	0.380	✓			
S	0.740	0.780	0.760	✓			
T	0.240	0.280	0.255	✓			
U	0.370	0.410	0.380	✓			
V	0.740	0.780	0.750	✓			
W	0.740	0.780	0.760	✓			

Measured by: M.A	Audited by: J.F.	Prototype Approval:	N/A
Date: 09/01/14	Date: 09/01/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

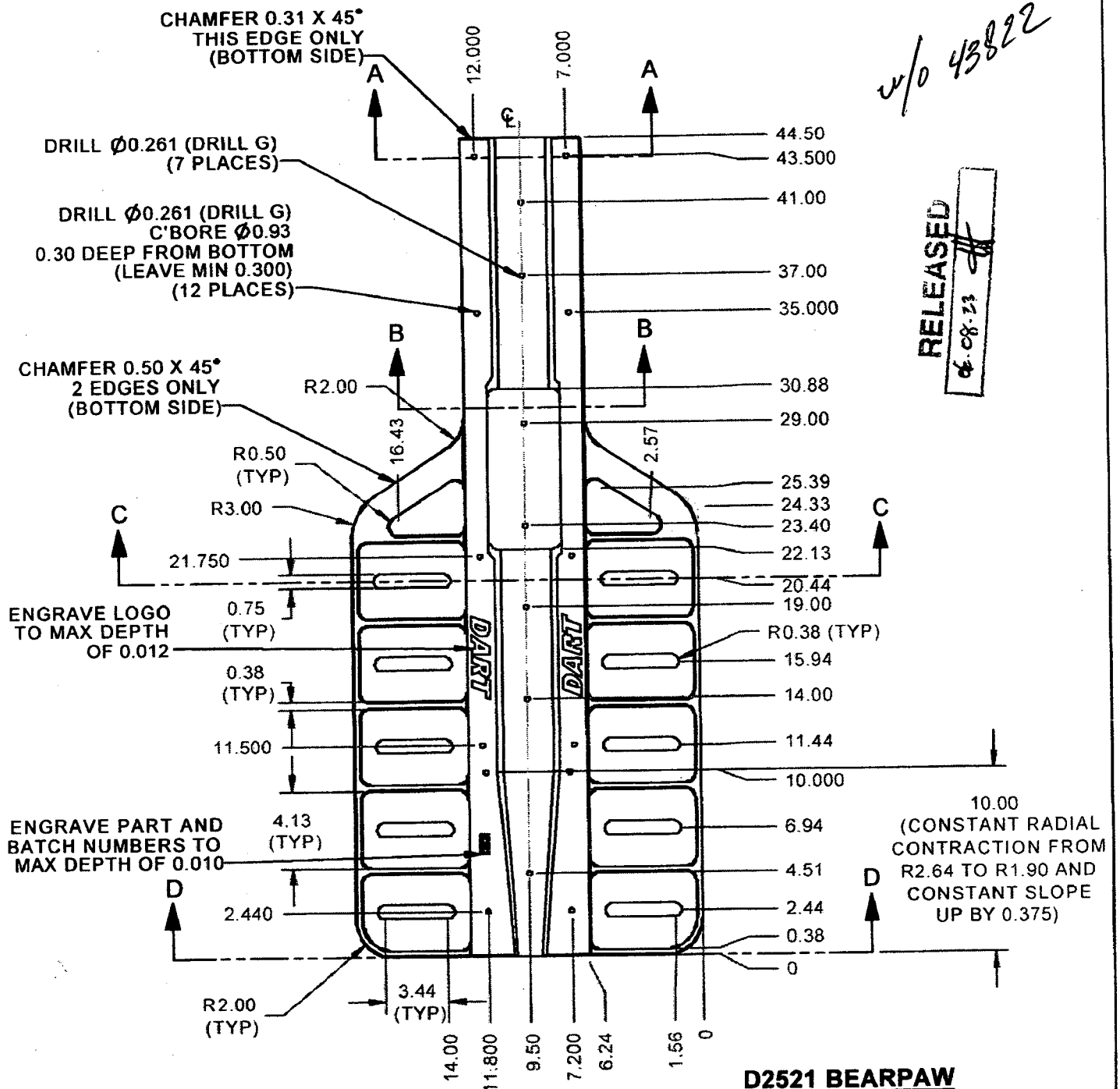
w/o 43822

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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 2 OF 3 SCALE 1:8	

**NOTES:**

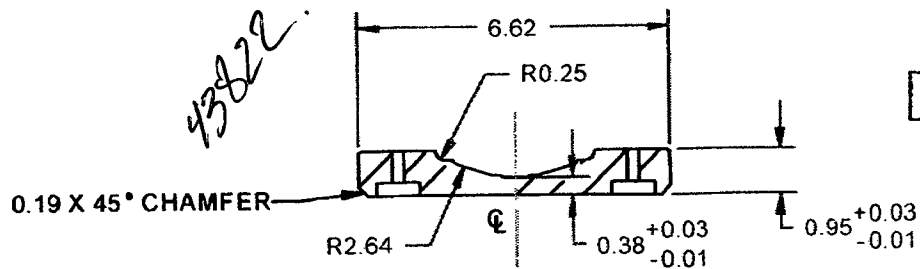
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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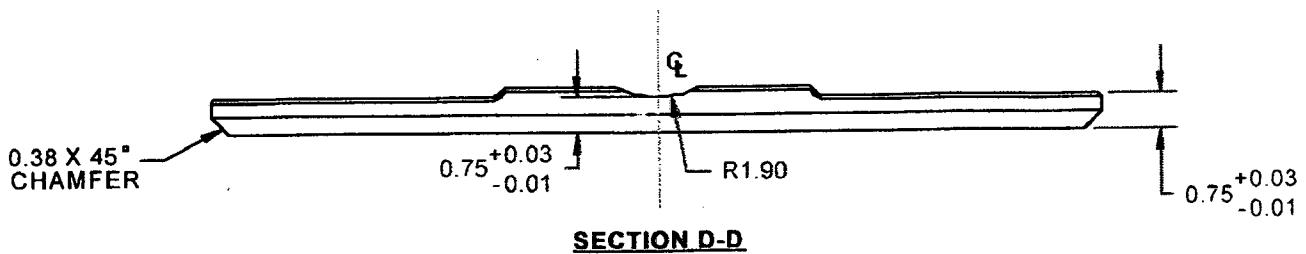
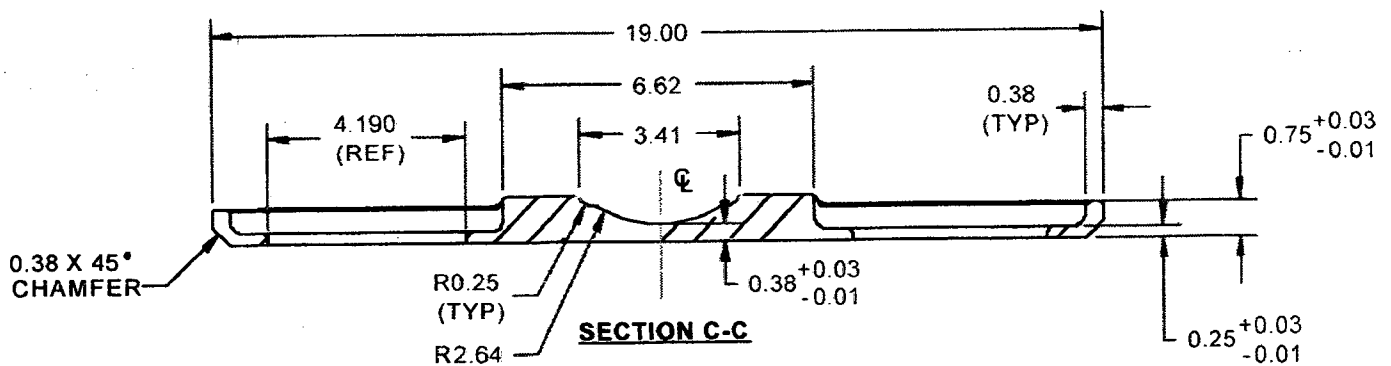
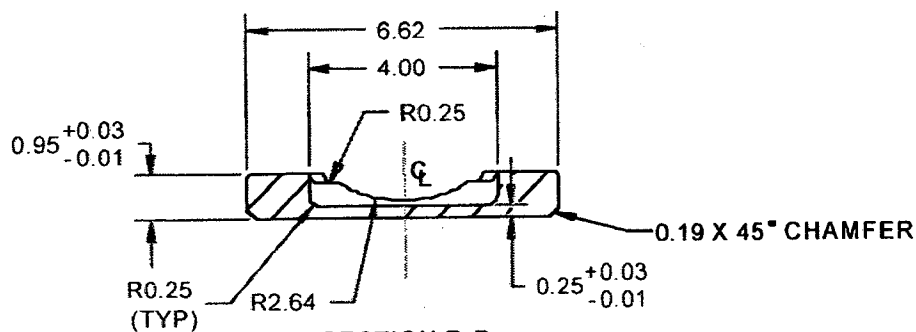
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3 SCALE 1:4	

**RELEASED**

06.08.23

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